

# Work Order ID 64690

Tuesday, December 14, 2010 10:30:28 AM



Page 1

Item ID:	D3826-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib / Gusset Assembly					
Start Date:	12/14/2010	Start Qty:	6.00		Cust Item ID:	
Required Date:	12/20/2010	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	12/14/14	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3826	Rev B								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- use DT9434 to assemble D2325 support gusset together 2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod Batch: <u>M114649</u>								

10/12/21 (6x)

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

10.12.23

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

8 01/2/23

(46)

# Work Order ID 64690

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Item ID: D3826-041

Accept



Setup Start



Revision ID:

Item Name: Rib / Gusset Assembly

Stop



Start Date: 12/14/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/20/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location:

0.00



Packaging

*Basket coll*

Memo

0.00

Packaging

*10/12/23*



140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/12/23*

*2/10-12-23*

# Picklist Print

Tuesday, December 14, 2010 10:30:33 AM

Page 1

Work Order ID: 64690

Parent Item: D3826-041

Parent Item Name: Rib / Gusset Assembly



Start Date: 12/14/2010

Required Date: 12/20/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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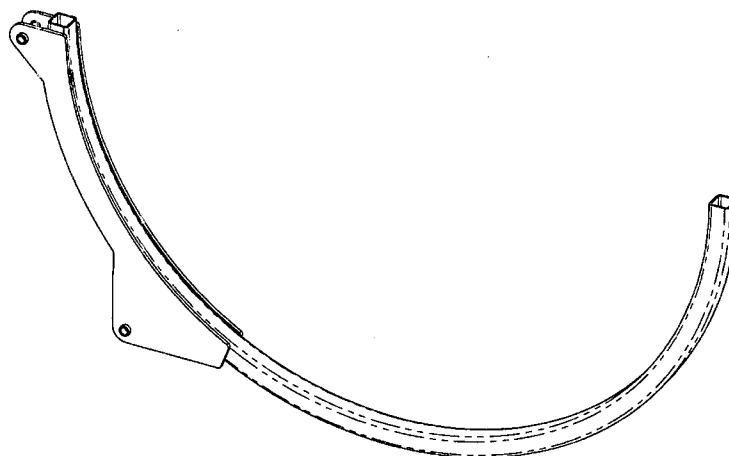
✓ D2235-1  Basket Rib		Manufactured	No				Each	8.0000	1	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				8					
					64250			8					
✓ D3929-041  Gusset Assembly		Manufactured	No				Each	6.0000	1	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				6					
					64110			6					
✓ D3929-042  Gusset Assembly		Manufactured	No				Each	1.0000	1	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				1					
					64111			1					

~~B64627 (5x)~~ *10/12/20*  
~~B64111 (1x)~~  
*(4x) B64626 (2x)*  
*10/12/20*  
  
~~B64627 (5x)~~ *10/12/20*  
*(1x)*

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44696






*Pl 1012-14*



**D3826-041 RIB/GUSSET ASSY**

**RELEASED**  
*8/10/12 MB*

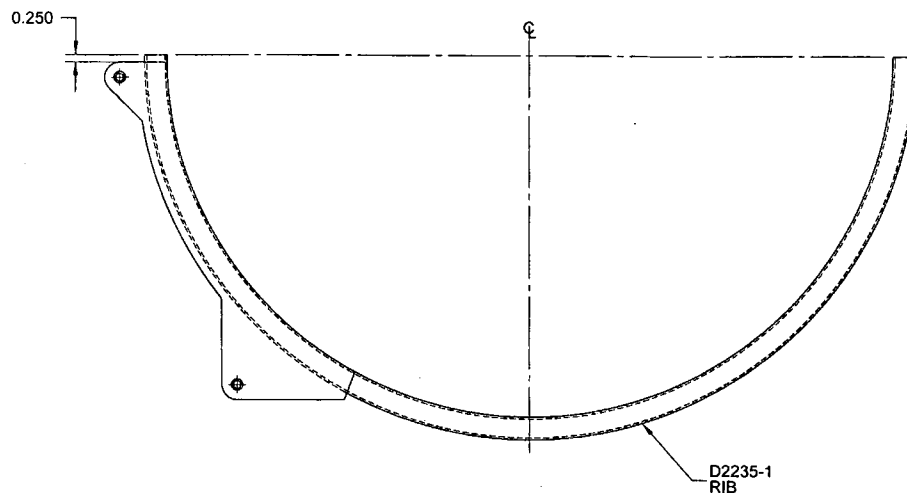
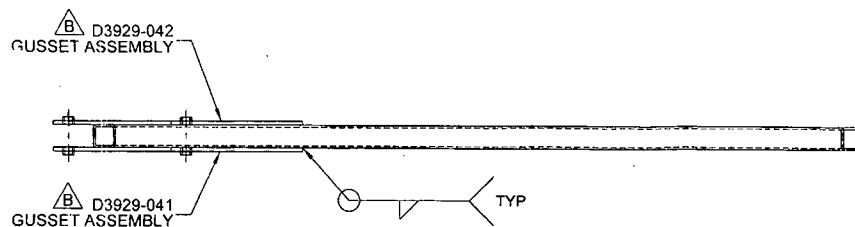
- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 3.32 lbs

B	D3929-041/042 WERE D2325 (ZN D3-1 & ZN D6-2). UPDATED WEIGHT (ZN A8-1) REASON: SEE NCR#09-042.		MB	09.04.16
A	NEW ISSUE		MB	08.09.23
REV.	DESCRIPTION		BY	DATE
DESIGN			<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN				
CHECKED			DRAWING NO.	REV. B
MFG. APPR.			D3826	SHEET 1 OF 2
APPROVED			TITLE	SCALE
DE APPR.			RIB/GUSSET ASSY	NTS
DATE	09.04.16		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

D  
C  
B  
A

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A



**D3826-041 RIB/GUSSET ASSY**

u1044690

**RELEASED**  
2/10/12-14

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
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8 7 6 5 4 3 2 1